



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3183-042

Job Sheet 202990



Part No: D3183-042

Job Qty: 3 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/19

Job Tracking No:

Due Date: 11/21/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C1 IPP Rev:Pick:A 04.02.18 New issue KJ/DS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 4 Axis	3 pcs	11/21/19		1.00	10.12	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	3 pcs	11/21/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

DAS
64
9-89

11/15/19



Container No: S232446



Part: D3183-042

Job No: 202990

Serial No/Batch: S232446

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/15/19

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CANADA
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Plex 11/7/19 8:33 AM Dart.Renwick.Jennifer

11/7/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

DAS

WV64 2017/11/15
9-89

130 QC 8

3 pcs

11/21/19

0.00 0.00

QC 2 - 66

QC 2 - 64

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

QC 8 - 76

QC 8 - 61

Small Fab - 1 - B4B

Small Fab - 2 - B4B

Small Fab - 3 - B4B

Small Fab - 4 - B4B

Small Fab - 5 - B4B

Small Fab - 6 - B4B

Small Fab - 7 - B4B

Small Fab - 8 - B4B

Small Fab - 9 - B4B

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

140 Small Fab - 2 - B4B

3 pcs

11/21/19

0.00 0.12

MAY 19 2020

150 QC 5

3 pcs

11/21/19

0.00 0.00

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11/7/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

DAS

40

MAY 20 2020

9-89

160 Packaging 3-1 - Stock - B4B 3 pcs

11/21/19

0.00 0.00

QC 5 - 40

QC 5 - 61

QC 5 - 81

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS

28

9-89

170 QC 21 - SA

3 pcs

11/21/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

DAS

21

9-89

MAY 20 2020

Part Op 110 - 1-Cut blanks: (1.500" x 2.000") 4.300" long 2-Machine D3183-2 as per Folio FA320 and Dwg D3183 Identify as
 Descriptions: D3183-2 2-Debur 3-Scribe batch number

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8- Inspect parts - second check

140 - Assemble D3183-041 as per Dwg D3183.

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation
M17-4-B2.000X1.500	17-4 SS Bar 2.00 x 1.500	1.0740 ft (.358 ea)	110-HAAS 4 Axis
D3121-21	Bolt	6 pcs (2 ea)	140-Small Fab - 2 - B4B
D3183-045	Bearing Assembly	6 pcs (2 ea)	140-Small Fab - 2 - B4B

Container

FM127415

3273833

S278338

Plex 11/7/19 8:33 AM Dart.Renwick.Jennife

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	M17-4-B2.000X1.500	1	5	0
140-Small Fab - 2 - B4B	D3121-21	6	10	0
	D3183-045	6	23	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 202990
Description: Bracket		Part Number: D3183-2
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.162	+/-0.010	.160	✓		Vernier	
R0.25	+/-0.030	R.250	✓		Gaborit	
3.105	+/-0.010	3.109	✓		Vernier	
2.075	+/-0.010	2.084	✓		Vernier	
0.786	+/-0.010	.778	✓		high gauge	
0.162	+/-0.010	.160	✓		Vernier	
100°	+/-0.05°	100°	✓		Gaborit	
2.799	+/-0.010	2.800	✓		high gauge	
Ø0.392	+0.002/-0.000	.393	✓		micrometre + bearing	
1.90	+/-0.030	1.891	✓		Vernier	
0.218	+/-0.010	.215	✓		Vernier	
0.500	+/-0.010	.501	✓		Vernier	
3.881	+/-0.010	3.882	✓		high gauge	
4.17	+/-0.030	4.173	✓		high gauge	
Ø0.201 x 100 deep	+/-0.010	Ø0.200 x 100	✓		pin + vernier	
0.182	+/-0.010	.184	✓		Vernier	
0.070	+/-0.010	.060	✓		Vernier	
0.100	+/-0.010	.110	✓		Vernier	
4.8°	+/-0.05°	4.8°	✓		Gaborit	
0.381	+/-0.010	.374	✓		Vernier	
0.200	+/-0.010	.200	✓		Vernier	
0.435	+/-0.010	.431	✓		Vernier	
0.615	+/-0.010	.609	✓		Vernier	
0.032	+/-0.010	.032	MS		micrometre profondeur	

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: N/A
Date: 2019/11/15	Date: 19/11/20	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue (P/O D3183-042)	KJ/JLM	[Signature]